

Split

Dart Aerospace Ltd.

Date: Wednesday, 04/06/2008 8:31:00 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 03.250 SUPPORT
Job Number	: 39685 -A		
Estimate Number	: 10387		
P.O. Number	:	Part Number	: D29401
This Issue	: 04/06/2008 S.O. No. :	Drawing Number	: D2940 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 39390	Material	:
Written By	:	Due Date	: 27/06/2008 Qty: 10 Um: Each
Checked & Approved By	: JUD 08.6.04		
Comment	: Est. C 02.11.26 Reformat; Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM est E 08.03.19 Re-format Ec verified by DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK081	D2940-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)  
 D2940-1 TURNING DETAIL  
 Batch: B 39688

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS  
 1- Machine as per Folio FA079  
 2- Tumble & Deburr

J.L/H.A 08/08/02

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

H.A 08/08/02

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

B.S 08/08/06

5.0	POWDER COATING	POWDER COATING
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M108523



10X

Comment: POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3  
 \*\*\*\*\*Mask Inside Surface as per Dwg D2940\*\*\*\*\*

START TIME:  
 OVEN TEMPERATURE:  
 FINISH TIME:

9:50  
 400 °F  
 10:20

M.A 08/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 04/06/2008 8:31:00 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 39685

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

ml 08 08 18

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

0808-18

(10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: LG

ml 08 08 18

(10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/19

Job Completion



MF 08-08-18



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39685
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.153	0.153	0.154	0.154	0.151
AD	3.510	3.530		3.518	3.518	3.518	3.518	3.518
AE	1.633	1.673		1.661	1.661	1.654	1.654	1.654
AF	1.493	1.513		1.510	1.510	1.504	1.503	1.503
AG	0.040	0.060		0.051	0.051	0.054	0.049	0.0515
AH	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AI	0.140	0.160		0.152	0.153	0.151	0.149	0.150
AJ	2.518	2.538		2.525	2.525	2.528	2.528	2.523
AK	0.040	0.060		0.048	0.048	0.047	0.049	0.047
AL	0.010	0.020		0.012	0.012	0.012	0.012	0.012
AM	0.140	0.160		0.1495	0.149	0.153	0.155	0.151
AN	0.350	0.450		0.395	0.385	0.390	0.385	0.386
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.154	0.151	0.1495	0.151	0.1505
AQ	0.053	0.073		0.060	0.060	0.060	0.060	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.128	4.129	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: M.A	Date: 08/08/02
Audited by: [Signature]	Date: 08/08/06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 39685
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	27	88	49	510
HAAS Section								
AA	0.240	0.260		0.250	.250	.250	.250	.250
AB	0.490	0.510		0.500	.500	.500	.500	.500
AC	0.140	0.160		0.151	.152	.152	.154	.154
AD	3.510	3.530		3.518	3.520	3.579	3.521	3.521
AE	1.633	1.673		1.655	1.643	1.648	1.660	1.662
AF	1.493	1.513		1.503	1.493	1.494	1.508	1.508
AG	0.040	0.060		0.0525	.048	.050	.048	.045
AH	0.188	0.193		0.188	.188	.188	.188	.188
AI	0.140	0.160		0.151	.149	.148	.159	.158
AJ	2.518	2.538		2.523	2.528	2.528	2.528	2.528
AK	0.040	0.060		0.047	.049	.051	.053	.048
AL	0.010	0.020		0.012	.015	.015	.015	.015
AM	0.140	0.160		0.153	.145	.143	.150	.147
AN	0.350	0.450		0.390	.380	.370	.397	.394
AO	0.240	0.260		0.250	.250	.250	.250	.250
AP	0.150	0.170		0.1525	.154	.154	.153	.154
AQ	0.053	0.073		0.060	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.260	.260	.260	.260	.260
AT	0.053	0.073		0.063	.063	.063	.063	.063
AU	4.118	4.138		4.123	4.126	4.130	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: <i>TK</i>	Date: 08/08/02
Audited by: <i>SP</i>	Date: 05/08/06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>JA</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 39685
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.152	.151	.151	.153	.150
AD	3.510	3.530		3.520	3.520	3.519	3.519	3.522
AE	1.633	1.673		1.650	1.653	1.650	1.650	1.654
AF	1.493	1.513		1.496	1.500	1.499	1.497	1.498
AG	0.040	0.060		.051	.050	.052	.050	.050
AH	0.188	0.193		.189	.189	.189	.189	.189
AI	0.140	0.160		.153	.153	.150	.152	.151
AJ	2.518	2.538		2.526	2.528	2.528	2.527	2.527
AK	0.040	0.060		.051	.050	.051	.052	.050
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.149	.148	.150	.152	.149
AN	0.350	0.450		.380	.380	.380	.380	.380
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.153	.153	.151	.153	.156
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.126	4.126	4.127	4.128	4.129
AV								
AW								
Accept/Reject								

Measured by: J.L.	Date: 08/08/05
Audited by: J.P.	Date: 08/08/06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 39685
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.153	.152	.153	.153	.152
AD	3.510	3.530	WAVE	3.523	3.526	3.526	3.523	3.522
AE	1.633	1.673		1.654	1.654	1.657	1.655	1.655
AF	1.493	1.513		1.504	1.499	1.499	1.502	1.502
AG	0.040	0.060	WAVE	.055	.052	.049	.052	.053
AH	0.188	0.193		.189	.189	.189	.189	.189
AI	0.140	0.160		.153	.153	.151	.152	.153
AJ	2.518	2.538		2.527	2.527	2.527	2.529	2.528
AK	0.040	0.060		.051	.050	.051	.051	.051
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.151	.152	.153	.151	.151
AN	0.350	0.450		.380	.380	.380	.380	.380
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170	WAVE	.151	.155	.158	.153	.153
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.127	4.128	4.128	4.129	4.129
AV								
AW								
Accept/Reject								

Measured by: J.L.	Date: 08/08/06
Audited by: SP	Date: 08/28/06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

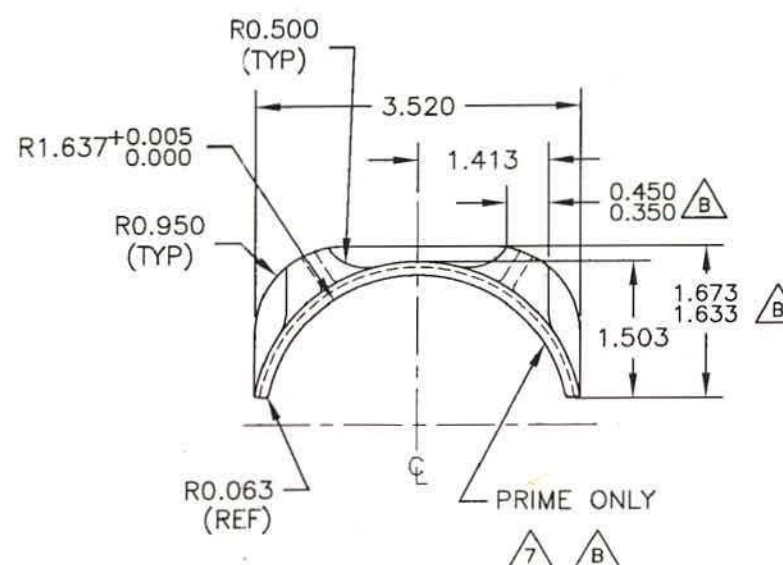
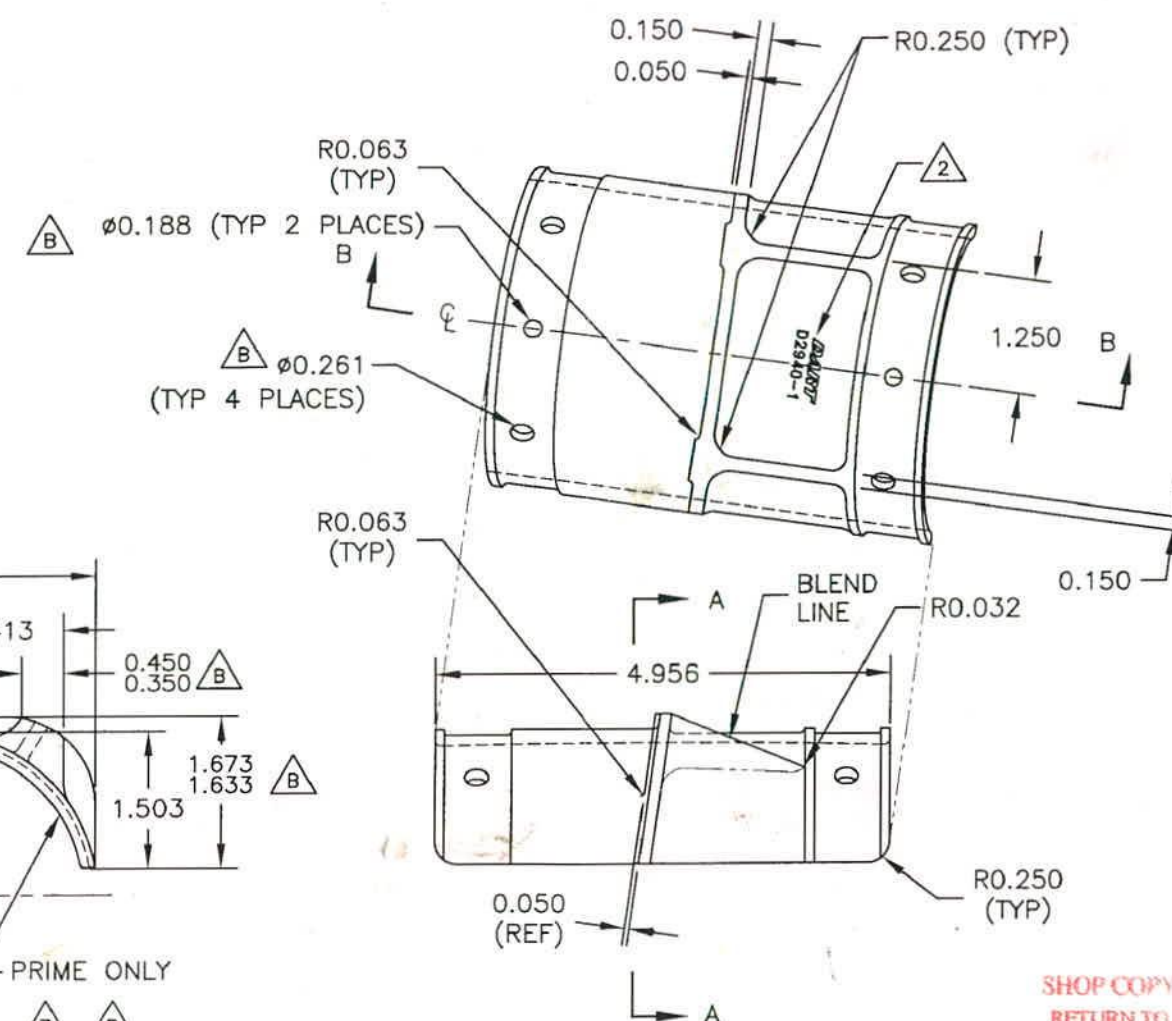
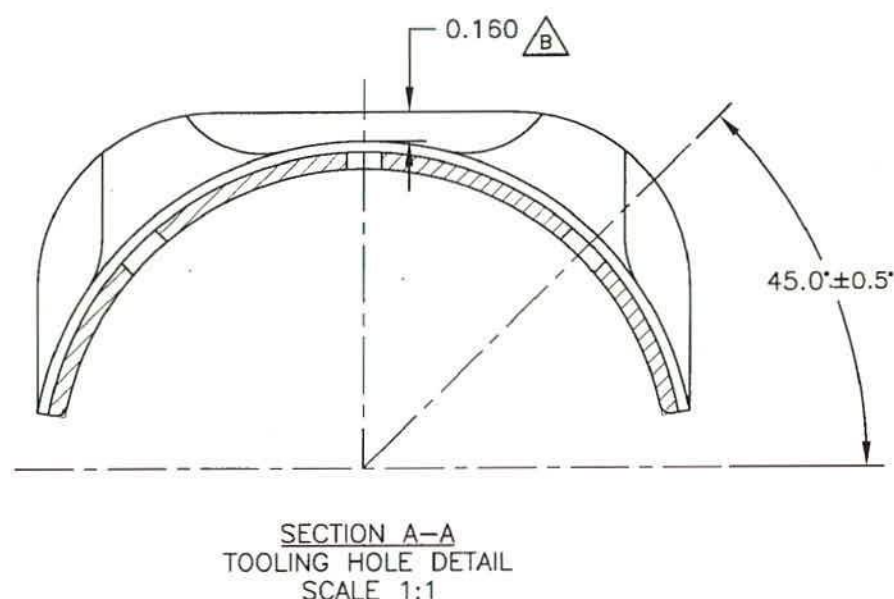
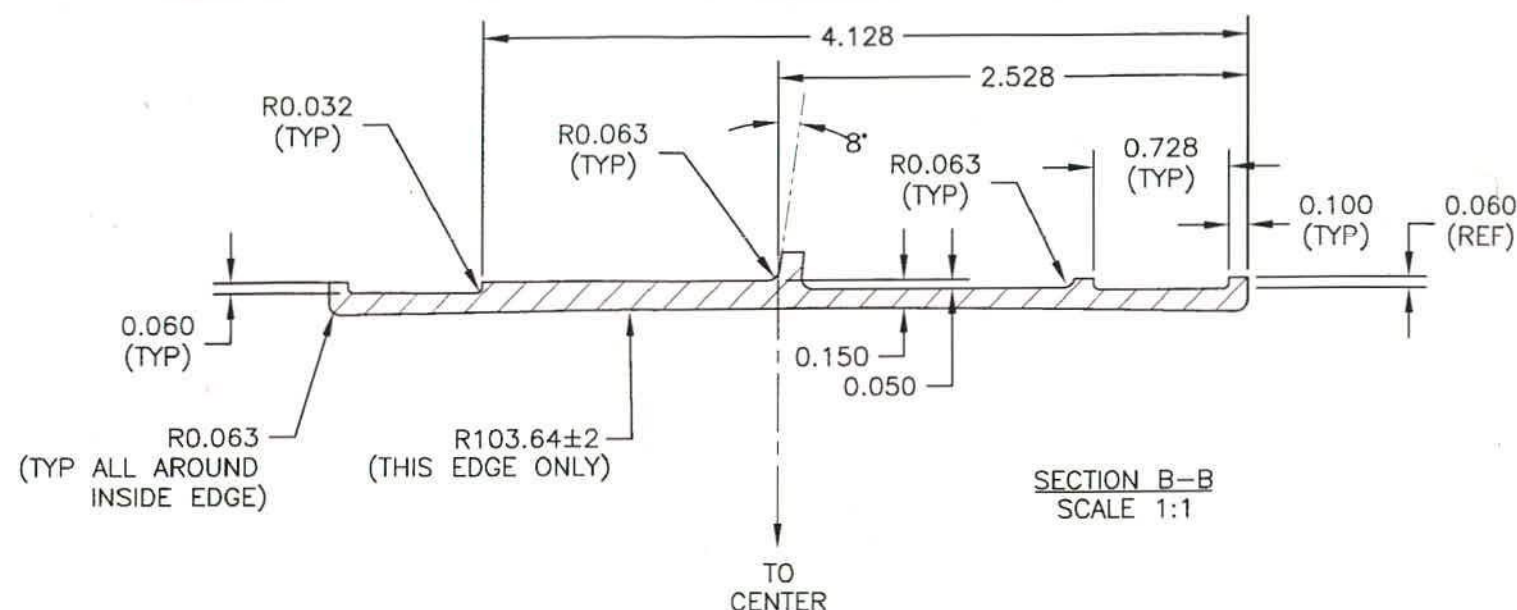
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**RELEASED**  
 67.4.24 UP  
 PER ECN 847



D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
 HEAT TREAT TO H900 CONDITION  
 (900°F FOR 1 HR, AIR COOL)  
 MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA  
 WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3  
 PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 39685

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 AND IS SUPPLIED ON THE EXPRESS CONDITION  
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
 OR COPIED OR COMMUNICATED TO ANY OTHER  
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 DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	9P	DRAWN BY PH
CHECKED	TH	APPROVED
DATE	07.03.16	TITLE
		0.3.250 SUPPORT
		SCALE
		1:2

**DART**

DART AEROSPACE LTD.  
 HAWKESBURY, ONTARIO, CANADA

REV. B  
 SHEET 1 OF 1

